

Work Order ID 64201

Page 1

Tuesday, November 30, 2010 11:18:46 AM

Item ID: D3829-1KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Upper LH

Start Date: 11/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3829

A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

*82**Wt
10/12/16*

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp:

150

Time IN:

*4:30**10/12/15*

Time OUT:

*2:00**10/12/16**2**BB**10/12/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA079 using tool DT9232
Dwg Rev: X
Folio Rev:

0.00

2

BR
12/12/10

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Visually inspect part for proper formation and texture

0.00

2

BR
10/12/11

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

2

DL
10/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 64201

Tuesday, November 30, 2010 11:18:47 AM

Page 3

Item ID: D3829-1KGY

Accept

Revision ID:

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Start Date: 11/30/2010 Start Qty: 2.00

Required Date: 12/14/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

0.00

0.00

2

BB

10/12/21

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Complete FAI document

0.00

0.00

2

BB

10/12/21

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/12/23

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 30, 2010 11:18:46 AM

Page 1

Work Order ID: 64201



Parent Item: D3829-1KGY



Parent Item Name: Vertical Tunnel, Upper LH

Start Date: 11/30/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 10/11/30 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased		No		100	sf	393.5600	2.71	5.447236			



Kydex steel grey



Location

therm

Loc Qty

393.56

Loc Code

111807

393.56

5,4472

Sh
10/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

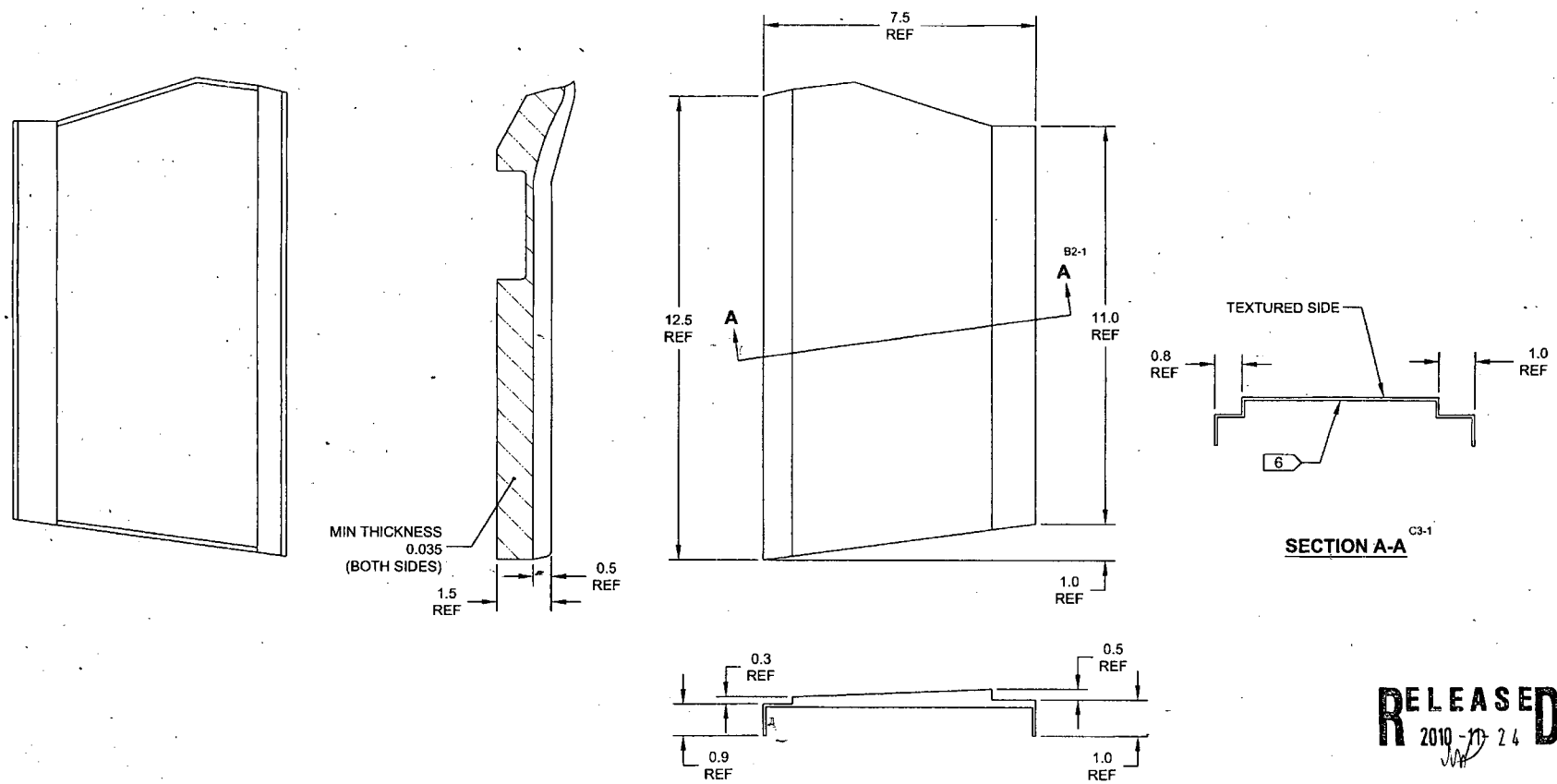
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

64701



D3829-1 VERTICAL TUNNEL, UPPER L/H

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 0.35 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9232 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3829-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3829-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

REV.	DESCRIPTION	SC	DATE
A	NEW ISSUE	SC	10.10.21
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D3829	SHEET 1 OF 3
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	VERTICAL TUNNEL (BELL 206 L/L1)	NTS
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RELEASED
2010-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

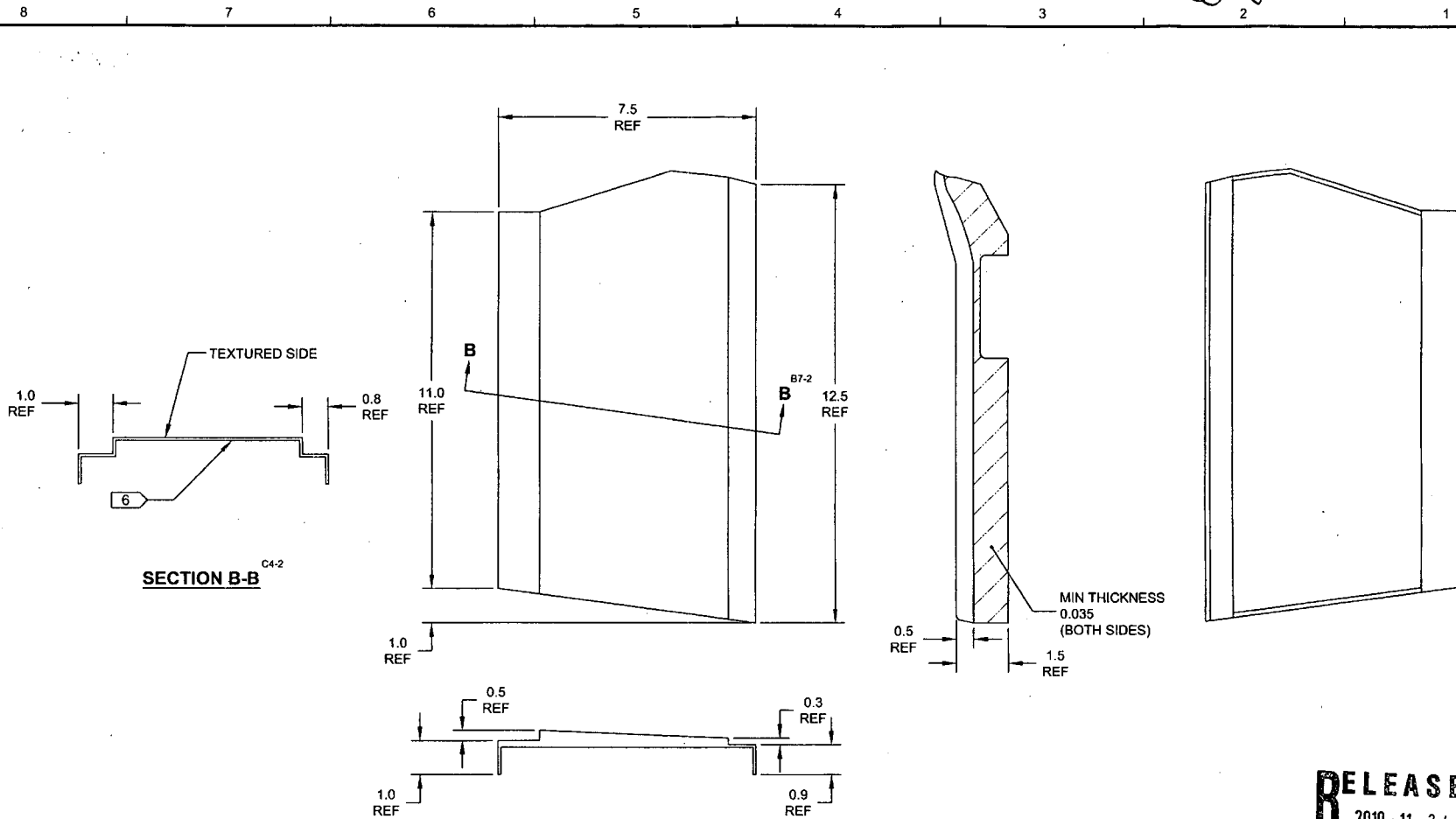
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

64701



D3829-2 VERTICAL TUNNEL, UPPER R/H

RELEASED
2010-11-24

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
 - 7) WEIGHT: 0.35 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9233 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3829-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3829-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.		D3829	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 L/L1)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

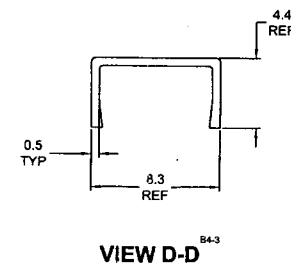
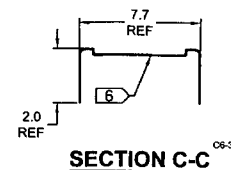
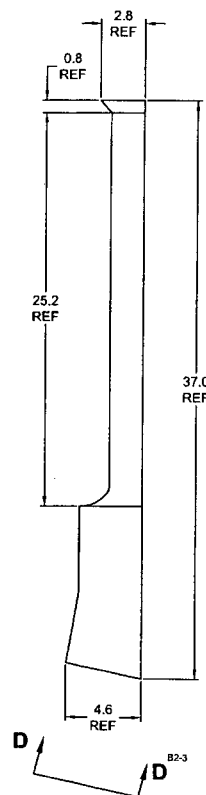
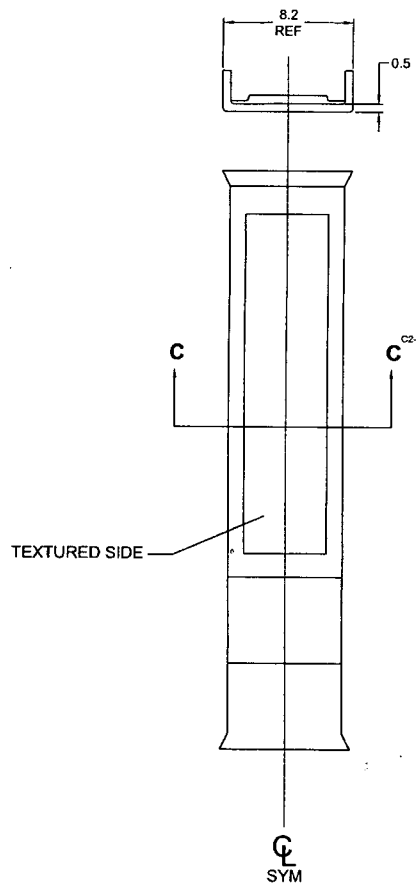
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

64201



RELEASED
2010-11-24

D3829-3 VERTICAL TUNNEL, AFT CENTER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 1.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9226 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3829-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3829-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3829	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 L/L1)	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64201
Description: VERTICAL TUNNEL Upper LH.		Part Number:	D3829-1 KGY
Inspection Dwg: 3829	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>JB</i>	Date: 10/12/20
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.5	REF	7.490	✓			
12.5	REF	12.49	✓			
1.0	REF	1.12	✓			
.9	REF	1.12	✓			
.050	MIN	.052	✓			
.035	MIN	.050	✓			

Measured by: <i>JB</i>	Date: 10/12/20
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Audited by: <i>S</i>	Date: 10/12/20
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14